

Date: Monday, 08/12/2008 1:53:15 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET LID ASSEMBLY
Job Number :	43941A		
Estimate Number :	10206		
P.O. Number :		Part Number :	D2989041
This Issue :	08/12/2008	Drawing Number :	D2989 REV D
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	D
Previous Run :	43819A	Material :	
Written By :		Due Date :	22/12/2008
Checked & Approved By :	JUD 08.12.08	Qty:	1 Um: Each
Comment :	Est Rev:I Removed D2989-043 05-11-03 JLM Est Rev:J 08-08-29 revC as per dwg DD verified by:EC Est Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC Est Rev:L 08-12-02 revD as per dwg DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2506	Label Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Label Plate

batch: B39457

SY 09/01/07

2.0	D25127	Rib
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Rib

batch: B43987 → 1x

SY 09/01/07

3.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Mounting Bracket

batch: B40895 → 2x

SY 09/01/06

4.0	D298913	Rib
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rib

batch: B43993 → 2x

SY 09/01/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 43941A

Part Number: D2989041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D298917	Rib
-----	---------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Rib
batch: B 43994 → 2x

SY 09/01/07

6.0	D298919	Rib
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Rib
batch: B 43995 → 2x

SY 09/01/07

7.0	D38323	Mesh (Lid)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Mesh (Lid)
batch: B 44013 → 1x

SY 09/01/07

8.0	D38333	Mesh (Lid End)
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Mesh (Lid End)
batch: B 44016 → 2x

SY 09/01/07

9.0	D3836041	Rib Assembly (Basket Lid, LH)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Rib Assembly (Basket Lid, LH)
batch: B 44018 → 1x

SY 09/01/07

10.0	D3836042	Rib Assembly (Basket Lid, RH)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Rib Assembly (Basket Lid, RH)
batch: B 44019 → 1x

SY 09/01/07

11.0	D3852041	Rib Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Rib Assembly
batch: B 44022 → 1x

SY 09/01/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/12/2008 1:53:15 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 43941A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3852042

Rib Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly

batch: B44023 → 1x

09/01/07

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig

3- remove from jig and weld lable plate as per dwg D2989

A/R ER316 S.S. Rod Batch: M108775

09/01/07

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-01-13

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/13

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

✓ 1- Plug holes prior to powder coating

✓ 2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

3-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: M110211

Wing Walk: M109917

09/01/15

1ST COAT:

START TIME: 9:00AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 9:30AM

***** 2nd coat if necessary *****

2ND COAT:

START TIME: X

OVEN TEMPERATURE: X

FINISH TIME: X

09-01-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 43941A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

g m ~~FA~~ 09/01/15 ①

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/19 J

Job Completion



11F 09-01-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

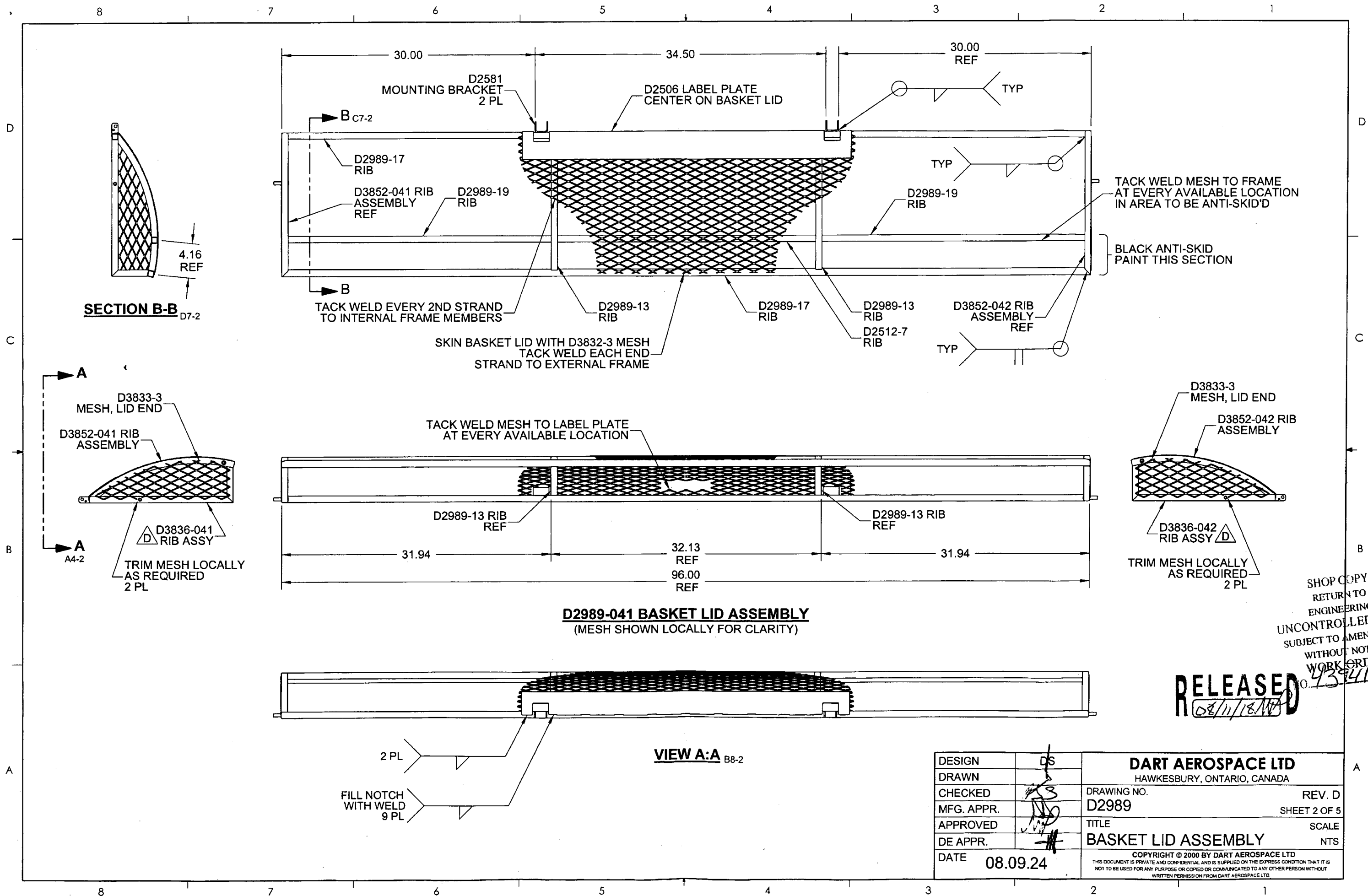
D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.09.24		

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004



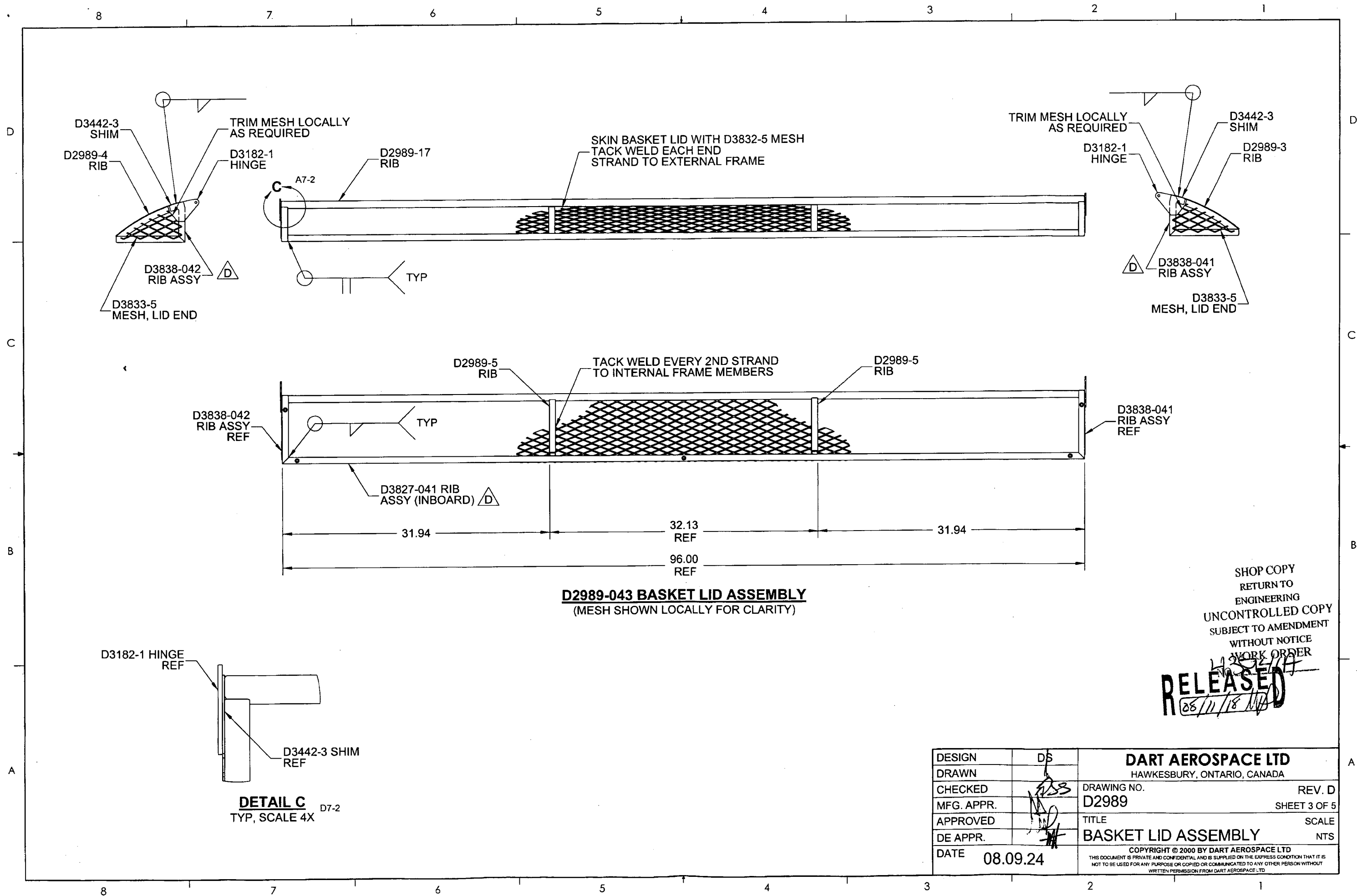
D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

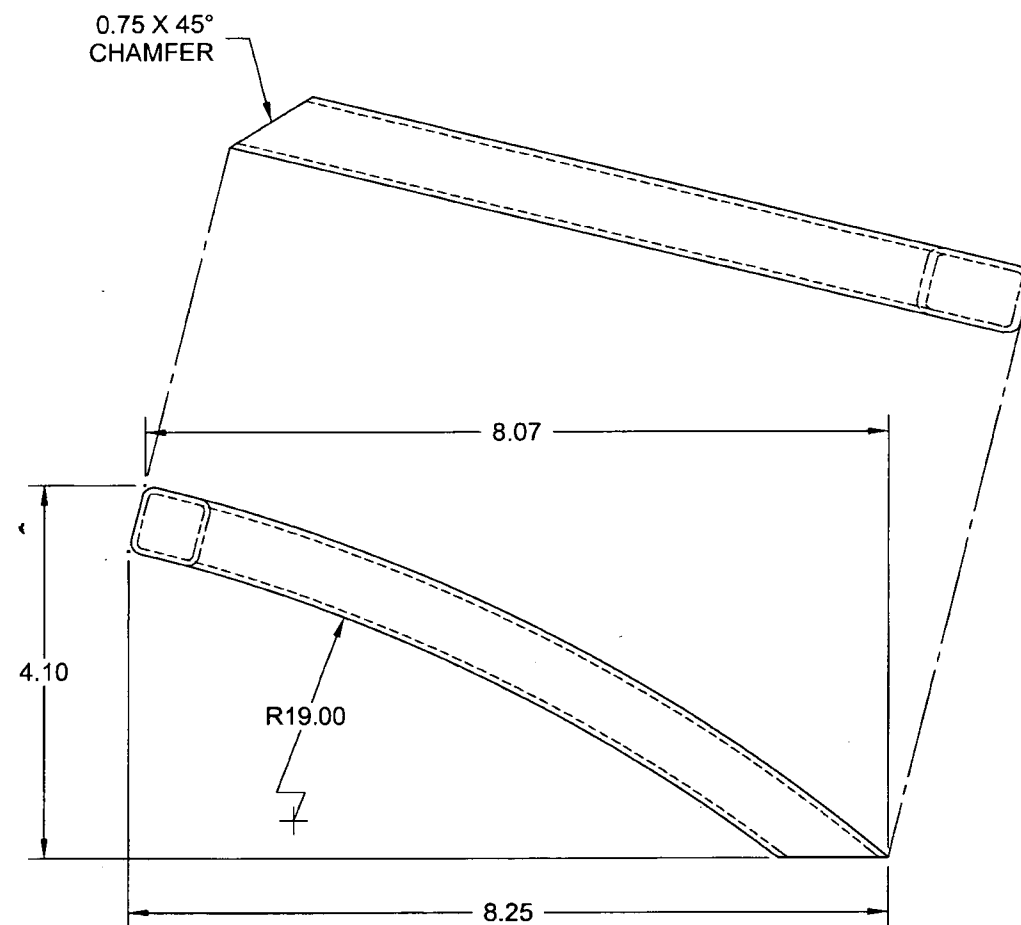
VIEW A:A B8-2

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WORK ORDER
43941A

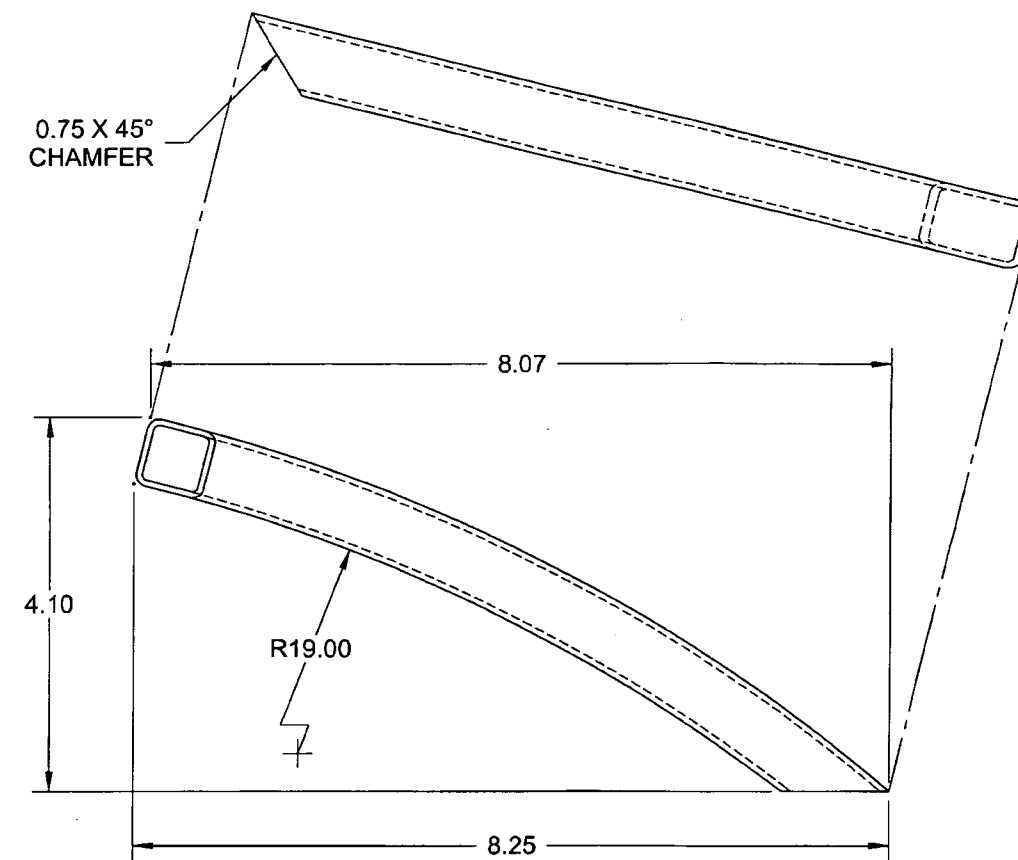
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08/11/18

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CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
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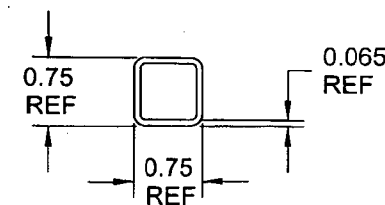


D2989-3 RIB



D2989-4 RIB

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

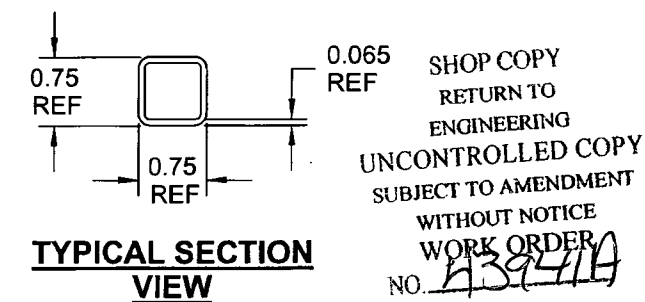
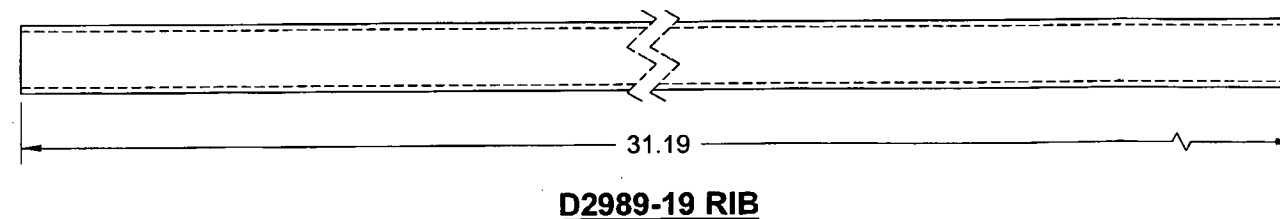
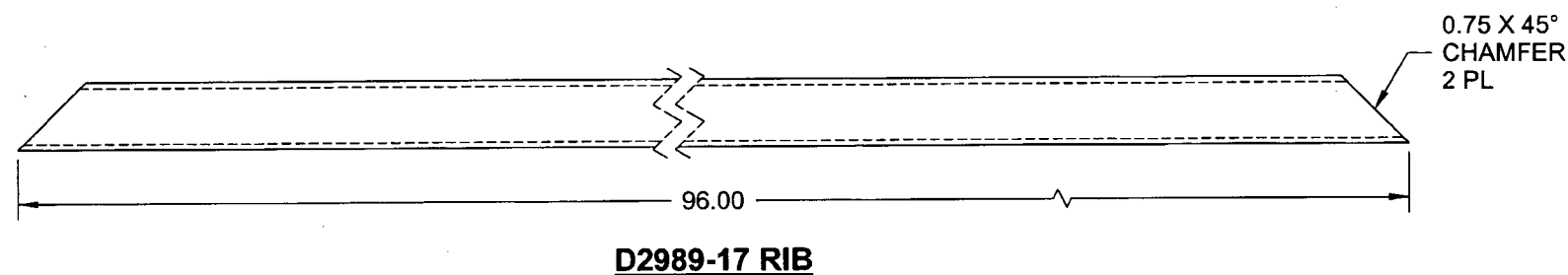
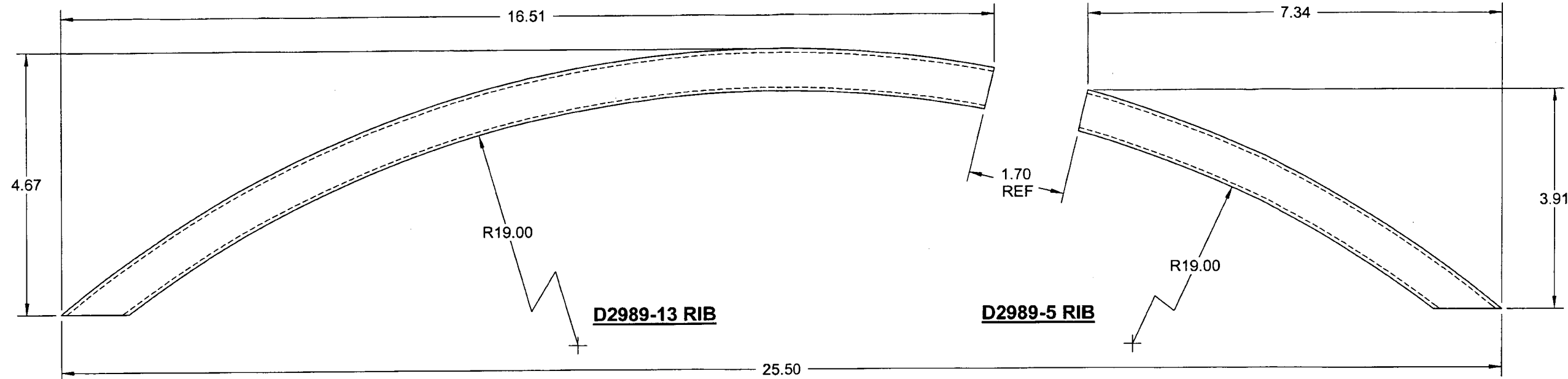


TYPICAL SECTION VIEW

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MFG. APPR.		SHEET 4 OF 5	
APPROVED		TITLE	SCALE
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**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
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CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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